

Work Order ID 70900

Friday, June 17, 2011 7:35:27 AM



Page 1

Item ID: D3234-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/16/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: Date: 11-06-17 Tooling: Date: QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3234

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3234 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

2024 .050

B11-6-232 (B)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 w/06/173(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Memo

0.00

0.00

Hand Finishing

2 AL 11-6-23

140



QC

Memo

0.00

0.00

Quality Control

2 6 11-6-23

150



Packaging

Memo

0.00

0.00

Packaging

Identify as per dwg & Stock Location: ST233

C fb (2) 11/06/24

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Page 3

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Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/27 JG

MF
11-06-24

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NOTE: Date & initial all entries

Picklist Print

Friday, June 17, 2011 7:35:33 AM

Page 1

Work Order ID: 70900



Parent Item: D3234-1



Parent Item Name: Doubler

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

122.3000

0.579

1.218947

3,



B11-6-03

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

122.3

117684

122.3

117684

63

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	709000
Description: Doubler		Part Number:	D3234-1
Inspection Dwg: D3234 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	✓		✓ BOZ	
0.300	+/-0.010	.298	✓		✓	
0.250	+/-0.010	.254	✓		✓	
2.270	+/-0.010	2.270	✓		✓	
2.841	+/-0.010	2.836	✓		✓	
2.627	+/-0.010	2.627	✓		✓	
5.993	+/-0.010	5.994	✓		✓	
7.108	+/-0.010	7.106	✓		✓	
8.228	+/-0.010	8.227	✓		PROWJ02	
10.463	+/-0.010	10.463	✓		✓	
10.77	+/-0.030	10.773	✓		✓	
2.51	+/-0.030	2.249	✓		✓	
13.333	+/-0.010	13.333	✓		✓ BOZ	
15.365	+/-0.010	15.369	✓		✓	
15.665	+/-0.010	15.665	✓		✓	
2.910	+/-0.010	2.909	✓		✓	
3.266	+/-0.010	3.263	✓		✓	
3.495	+/-0.010	3.499	✓		✓	
3.658	+/-0.010	3.660	✓		✓	
0.050	+/-0.010	.049	✓		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-6-23	Date: 11/06/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	
B	09.05.04	Dimensions update per Rev B	KJ/DD	

W/O:		WORK ORDER CHANGES					
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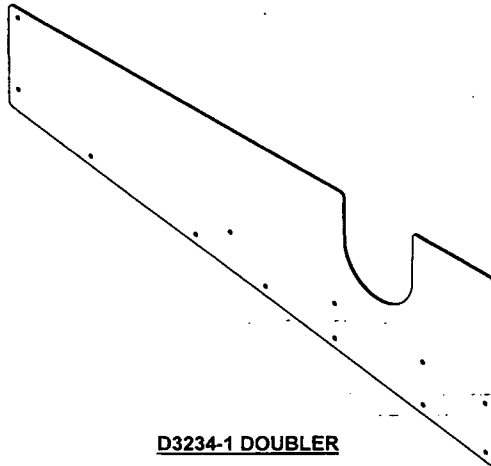
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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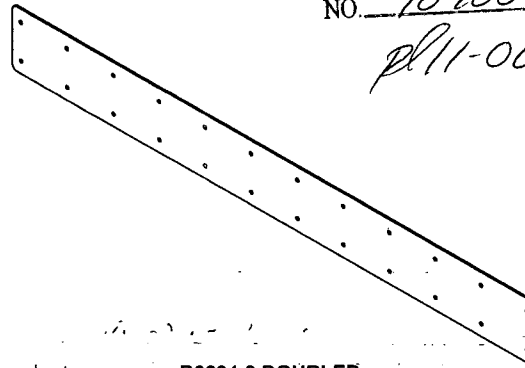
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70900

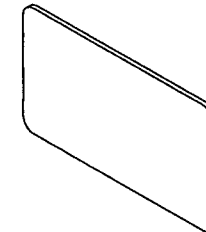
11-06-17



D3234-1 DOUBLER



D3234-3 DOUBLER



D3234-5 SPACER

NOTES:

1) MATERIAL: -1 & -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF DART SPEC M5052H32S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3234-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: -1: 0.30 lbs
-3: 0.15 lbs
-5: 0.01 lbs

RELEASED
08/12/15 NW

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-025.		AJS	08.11.24
A	NEW ISSUE		CP	03.11.19
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>[Signature]</i>	D3234	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS	
DATE	08.11.24	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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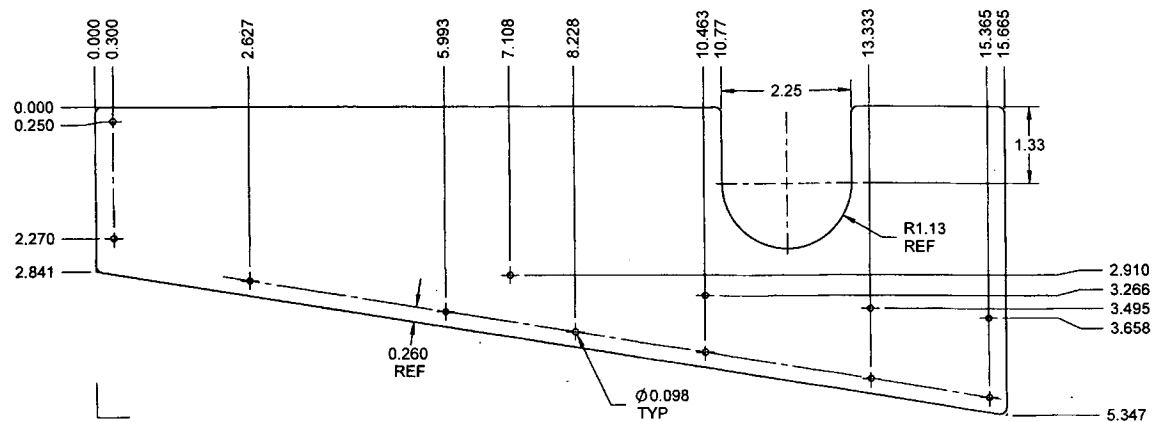
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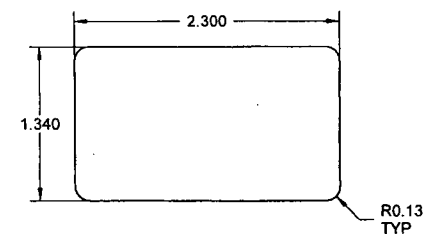
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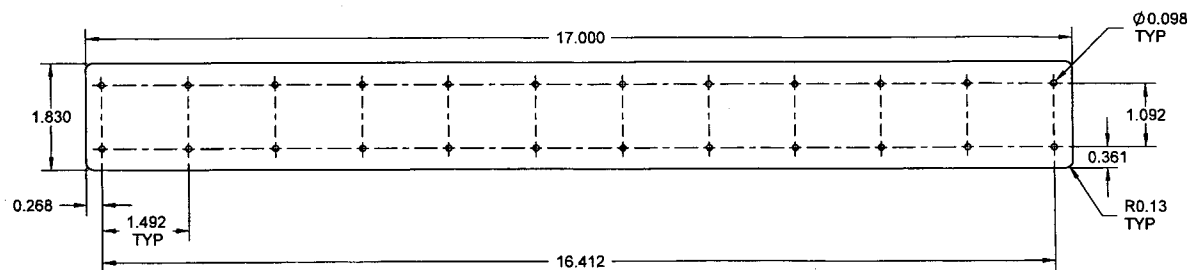
8 7 6 5 4 3 2 1



D3234-1 DOUBLER



D3234-5 SPACER



D3234-3 DOUBLER

RELEASED
08/12/15 NW

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3234	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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